

Work Order ID 79835

February-03-12 3:31:52 PM

ASAP

79835

Page 1

Item ID: D3537-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearpad
 Start Date: 03/02/2012 Start Qty: 50.00 *50* Cust Item ID:
 Required Date: 10/02/2012 Req'd Qty: 50.00 *50* Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/02/06 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3537	Rev C								

100 FLOW WATER JET 0.00
 100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3537Dwg Rev: C Prog Rev: C 2-Deburr if necessary

B12-2-9
 (54)

110 QC2- Inspect parts off machine FAI/FAIB 0.00
 110
 QC Memo 0.00
 Quality Control

B12-2-9

120 QC8- Inspect parts - second check 0.00
 120
 QC Memo 0.00
 Quality Control

8/2/02/10
 Counter
 (x54)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 03/02/2012 **Start Qty:** 50.00 ***50***

Cust Item ID:

Required Date: 10/02/2012 **Req'd Qty:** 50.00 ***50***

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

130

130

NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.2-
Identify as D3537-1

So 12/02/14

140

0.00

140

Large Fab

0.00

Large Fab

Memo

Large Fab

Qty	Description	Batch/A/R	2059B Hardcoat
M120892	1-Weld as per Dwg D3537 using Jig DT 82102-Remove any weld that penetrated through Wearpad if necessary		

54

12-03-05 JBL

150

QC10- Inspect visual per QSI004- ground welds	0.00
---	------

0.00

150

Memo

0,00

QC

Quality Control

5/17/06

center

414

W/O:		WORK ORDER CHANGES					
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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				count (454)			
170 *170* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: 3h10 370°F OVEN TEMPERATURE: 3h40 FINISH TIME: _____	0.00 0.00				54 50			12/03/08 11/18 489
180 *180* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				54			12/02/10

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>FPI</u>	0.00							
190									
Packaging	Memo	0.00				51			
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

MLJ 12/03/09

MLJ 12/03/09

12-03-09

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Picklist Print

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Work Order ID: 79835

79835

Parent Item: D3537-1

D3537-1

Parent Item Name: Wearpad

Start Date: 03/02/2012

Required Date: 10/02/2012

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	28.4700	0.106	5.578947			
									**				
M304S16GA													
304/316 Sheet .063													

Location

Loc Qty

Loc Code

MAT020

28.47

120243

28.47

119653

84

119653

(54)

6
B12-2-6

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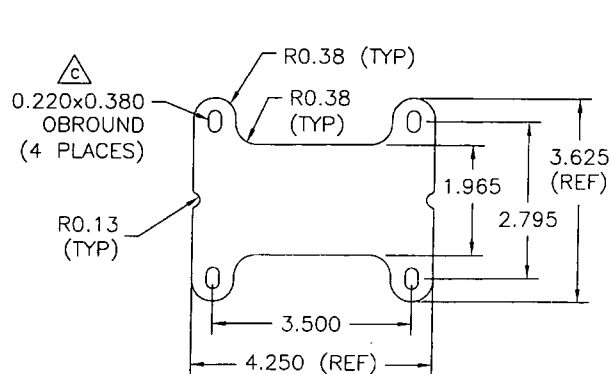
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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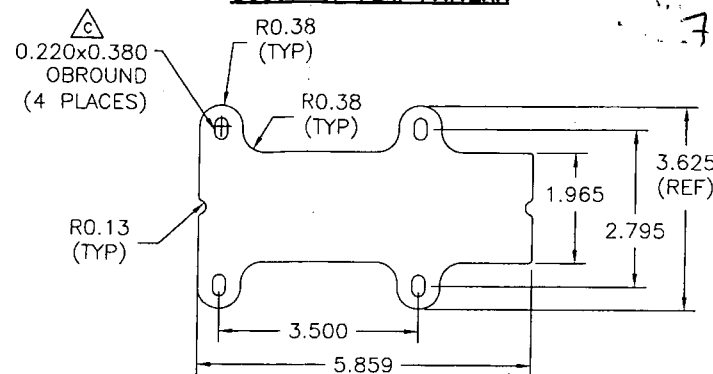
NOTE: Date & initial all entries

SECRET
 UNCLASSIFIED
 SUBMIT

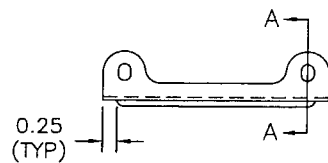
D3537-1F FLAT PATTERN



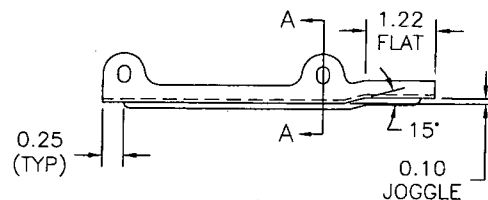
D3537-3F FLAT PATTERN



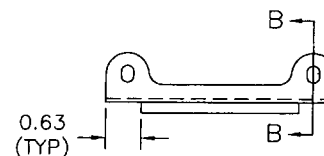
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



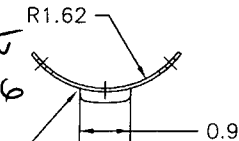
D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-1/-3/-5/-7 WEARPAD NOTES

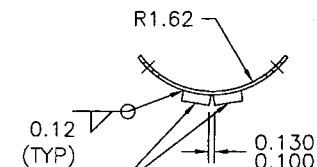
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
 (REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SECTION A-A



APPLY 2 LAYERS OF
 2059B HARDCOAT WELDS
 TO WITHIN 0.25 OF
 WEARPAD ENDS
 0.188 TO 0.250 THICK

SECTION B-B

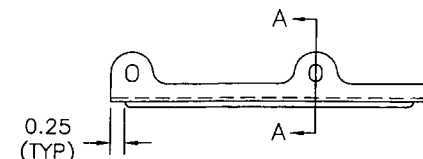


D2941-300
 REMOVE POWDER
 COAT FROM THESE
 SURFACES

UNDER REVIEW
 07.05.08 per ECN
 962

RELEASED

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	C.B.	DRAWN BY P.H.
CHECKED	#	APPROVED #
DATE	07.04.13	DRAWING NO. D3537
		TITLE WEARPAD
		REV. C SHEET 1 OF 1 SCALE 1:2

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 PORT HADLOCK, MA

W/O:		WORK ORDER CHANGES					
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